Work Orde Wednesday, May											Page 1
Item ID: Revision ID:	D3407-5			Accept					Setup Sta		
Item Name:	Ring								Sto	p III	
Start Date: Required Date: Reference:	5/18/2011 5/20/2011	Start Qty: 24.00 Req'd Qty: 24.00	1881/4   1881   1881   1881   1881/4   1881   1881   1881		Cust Item I Customer:	D:					
Approvals:	Process Plan	n:	Date/-05-18	Tooling: SPC (Y/N):		nte:		]	Run Sta Sto		
Sequence ID/ Work Center IE		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr					***************************************				
D3407	Rev	Е									
Waterjet FLOW CNC Waterje		FLOW WATER JET  Memo 1-Cut as per Dwg Rev: Prog Rev: 2-Break edge	Dwg D3407 es on grinder as per Dwg D3	0.00			-	B	11/06/	6, 6	

110

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

\_1B14-7-31 \_\_\_\_

									3
W/O:			WO	RK ORDER CHANG	ES				-
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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		*							
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	_ Date: _	
	Res	solution:	Disposition	n:	_ QA: N/C C	losed:		Date: _	
NCR:		,	WORK ORDE	ER NON-CONFORM	ANCE (NC	₹)			
DATE	STEP	Description of NC		tion B	Verifi	cation	Approval Chief Eng	Approval	
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng				tion C	QC Inspector
	·								

#### Work Order ID 69742

Wednesday, May 18, 2011 11:01:36 AM



Page 2

Item ID:

D3407-5

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Ring

**Start Date:** 5/18/2011

Required Date: 5/20/2011

Start Qty: 24.00 Req'd Qty: 24.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:\_\_\_\_\_

Tooling:

Set Up/

**Run Hours** 

Date:

Date:

Run

Start

Stop



Sequence ID/

Date:

SPC (Y/N):

Tool # Plan

Accept

Reject

Reject Insp.

Work Center ID

120

QC

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

**Tool ID** 

Code

Oty

Qty

Number Stamp

130

Packaging

Packaging

Identify as per dwg & Stock Location: W/A 070

0.00

\*\*\*\*\*STOCK IN LARGE FAB\*\*\*\*\*

PL 11-6-1



140

QC Quality Control QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/6/6 H MF 1206-02

WORK ORDER CHANGE  By Date Qty Approval Chief Eng / Prod Mgr  Part No:	Approval QC Inspector
Part No:PAR #: Fault Category: NCR: Yes No DQA: Date:	Approval QC Inspector
Resolution: Disposition: QA: N/C Closed: Date:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A Approval Chief English Action Description Sign & Section C Chief English Content of the C	
Resolution: Disposition: QA: N/C Closed: Date:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A Approval Chief English Action Description Sign & Section C Chief English Content of the C	
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Resolution: Disposition: QA: N/C Closed: Date:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A Approval Chief English Action Description Sign & Section C Chief English Content of the C	
DATE STEP Description of NC Section A Section B Section B Initial Action Description Sign & Section C Chief Eng	•
DATE STEP Description of NC Initial Action Description Sign & Verification Approval	
Section A Initial Action Description Sign & Section C Chief Eng	Approval
One Ling Officially Date	QC Inspector

#### **Picklist Print**

Wednesday, May 18, 2011 11:01:42 AM

Work Order ID: 69742

Parent Item: D3407-5

Parent Item Name: Ring



Start Date: 5/18/2011

Required Date: 5/20/2011

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP Rev:A New Issue 05-11-22 JLM

IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD

IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174B0.250X4.000		Purchased	No			100	f	8.7000	0.2666	6.735158	8-5		
										HB 11-	5-31		
17-4 SS Bar .250 X 4.00												_	

 Location
 Loc Oty
 Loc Code

 MAT050
 8.7

117130 8.7

117132



Part No: PAR #: Fault Category: NCR: Yes No DQA: Date  Resolution: Disposition: QA: N/C Closed: Date  NCR: WORK ORDER NON-CONFORMANCE (NCR)  Date Step Description of NC Corrective Action Section B			
Part No: PAR #: Fault Category: NCR: Yes No DQA: Date  Resolution: Disposition: QA: N/C Closed: Date  NCR: WORK ORDER NON-CONFORMANCE (NCR)  Description of NC Section A Section B Section C Chief En Prod Mg  Part No: PAR #: Fault Category: NCR: Yes No DQA: Date  Resolution: Disposition: QA: N/C Closed: Date  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A Approx Chief En Prod Mg	WORK ORDER (	S	
Part No:PAR #: Fault Category: NCR: Yes No DQA: Date  Resolution: Disposition: QA: N/C Closed: Date  NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A Corrective Action Section B Section C Chief Et al. (Approximately 100 of NC Section A Corrective Action Description Sign & Section C Chief Et al. (Approximately 100 of NC Section A Corrective Action Description Sign & Section C Chief Et al. (Approximately 100 of NC Section A Corrective Action Description Sign & Section C Chief Et al. (Approximately 100 of NC Section A Corrective Action Description Sign & Section C Chief Et al. (Approximately 100 of NC Section A Corrective Action Description Sign & Section C Chief Et al. (Approximately 100 of NC Section A Corrective Action Description Sign & Section C Chief Et al. (Approximately 100 of NC Section A Corrective Action Description Sign & Section C Chief Et al. (Approximately 100 of NC Section A Chief Et al.	PROCEDURE CHANGE	Date   Gity   Cinci Lity   Co.	oroval espector
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Section A Initial Action Description Sign & Section C Chief Er	OT NC	Verification Annroyal Ann	proval
	A Initial Action Des	Sign & Section C Chief Eng. OC In	QC Inspector

DART AEROSPACE LTD	Work Order:	69742
Description: Tow Ring	Part Number:	D3407-5
Inspection Dwg: D3407 Rev: E		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.)57	7		U BOZ	
Ø3.000	+/-0.030	3,∞1	8		ν	
Ø2.050	+0.012/-0.001	<u> შიც</u> 53	8		V	
0.75	+/-0.030	J72	8		V	
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Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11-5-31	Date: Wolde	Date:	N/A

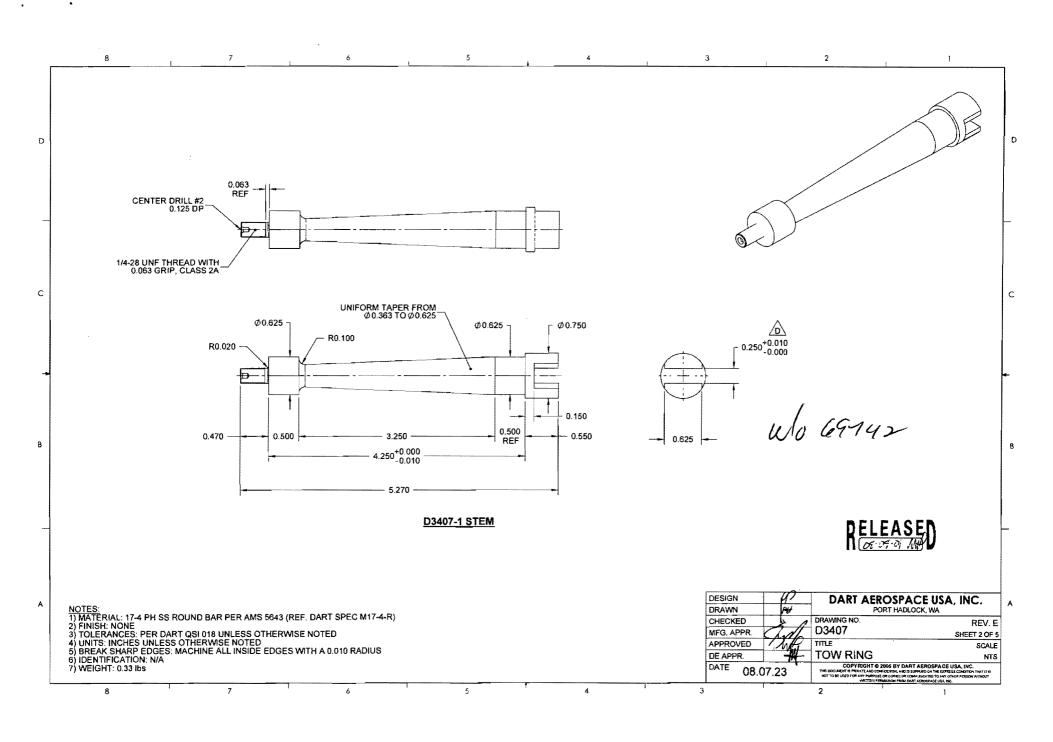
Rev	Date	Change	Revised by	Approved
Α	07.02.02	New Issue	KJ/JLM	
В	07.09.18	Tolerance revised	KJ/EC	1
С	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM ,	11/1
D	09.05.04	Dwg Rev updated	KJ/DD	6/1/
		-		

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W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	CEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	Date: _	<del></del>
	R	esolution:	Date: _						
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DATE	STED	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	ŞTEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
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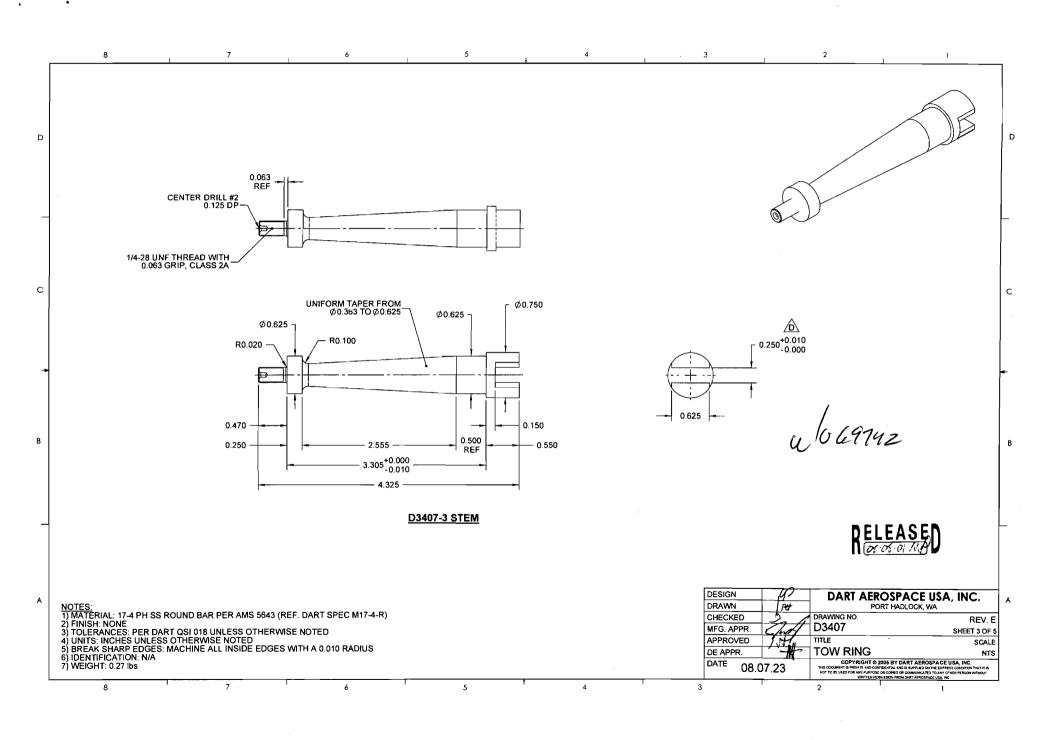
QTY -043 QTY PART NUMBER DESCRIPTION D3407-041 TOW RING D3407-043 TOW RING D3407-045 **TOW RING** D D3407-1 STEM D3407-3 STEM D3407-5 RING D3407-7 STEM D3407-5 RING -D3407-5 RING -D3407-5 RING 8 8 V 1/8 D3407-1 STEM 6 D3407-3 STEM D3407-7 STEM **D3407-041 TOW RING D3407-045 TOW** RING ♠ **D3407-043 TOW RING** ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY 08.07.23 SHOP COPY D3407-1/-3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3): D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/-3 (ZN B6-4); REASON: PRODUCTION FACILITY **RETURN TO** 08.04.07 **ENGINEERING** -1/-3 LONGER FOR FIT W/WASHER CP 05.09.09 **UNCONTROLLED COPY** UPDATE DIAMETER, THREAD CLASS ADDED CP 05.06.17 SUBJECT TO AMENDMENT NEW ISSUE Α 05.03.16 REV. DESCRIPTION BY DATE WITHOUT NOTICE DESIGN DART AEROSPACE USA, INC. WORK ORDER )\_49142 DRAWN PORT HADLOCK, WA 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A DRAWING NO. CHECKED REV. E D3407 Q111-05-18 MFG. APPR. SHEET 1 OF 5 APPROVED SCALE 5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER (1) WEIGHT: D3407-041 - 0.60 bs, D3407-043 - 0.53 bs, D3407-045 - 0.61 lbs
8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING TOW RING DE APPR. NTS COPYRIGHT @ 2005 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS EXPRESS ON THE EXPRESS CONCITION NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON. DATE 08.07.23

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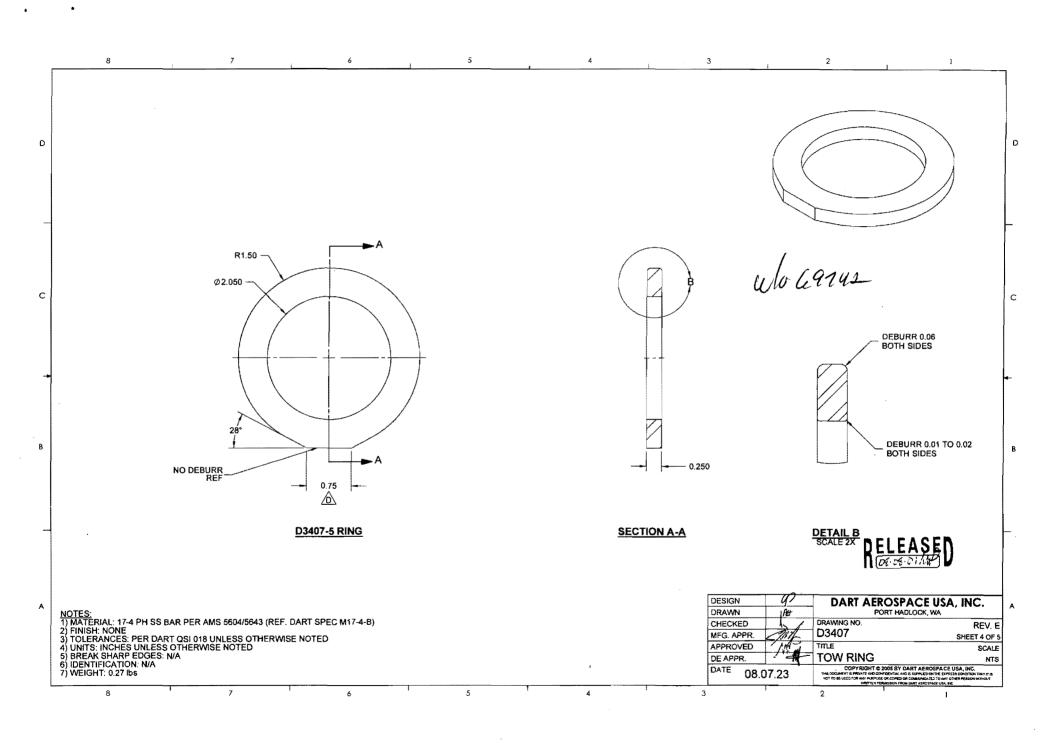
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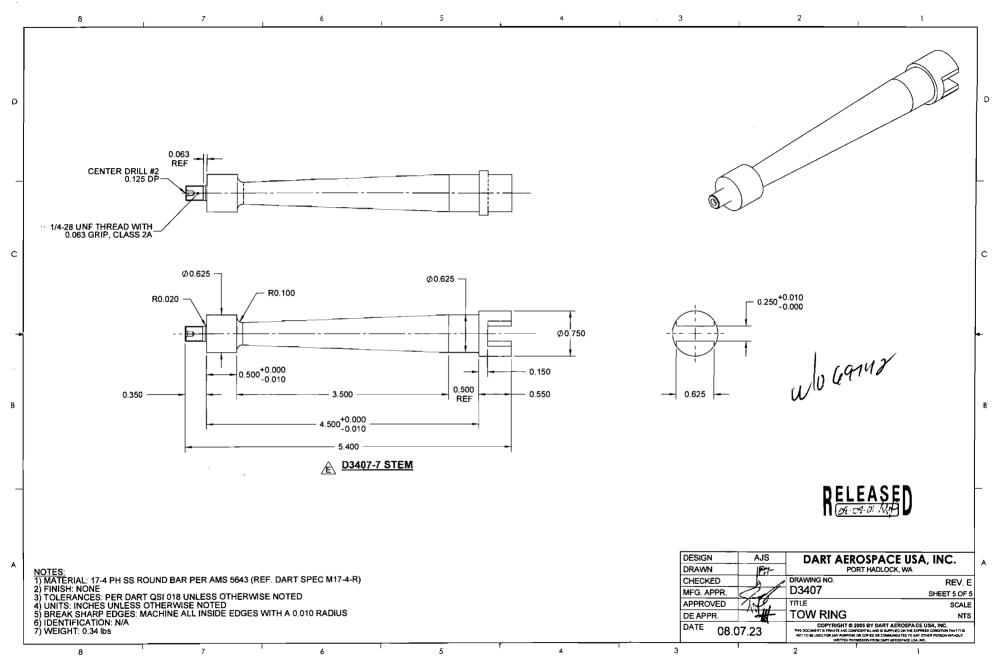
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